



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2792-130**Job Sheet 205209**

5255044

Part No: D2792-130**Job Qty:** 60 pcs**Part Name:** Extrusion**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/3/20**Job Tracking No:****Due Date:** 3/13/20**Created By:** Kimberley Guerin**Type:** Stock**Description:****Note:** DWG REV A1**Ship Via:****Bill of Materials**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S255044**Part:** D2792-130**Job No:** 205209**Serial No/Batch:** ~~S255044~~**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

S255044

Date: 02/14/20

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	60 pcs	3/13/20	3/13/20	0.00	0.00	Purchasing - 1	DAS 82
							Purchasing - 2	FEB 12 2020
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	60 pcs	3/13/20	3/13/20	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	DAS 82
							Packaging 2 - 7 - B4B	9-89
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	FEB 12 2020
							Packaging 2 - 10 - B4B	
							Packaging 2 - 37 - B4B	
120	QC 6	60 pcs	3/13/20	3/13/20	0.00	0.00	QC 6 - 9	DAS 40
							QC 6 - 68	9-89
							QC 6 - 61	DAS 82
							QC 6 - 40	9-89
							QC 6 - 81	FEB 14 2020
130	Packaging 3-1 - Stock - B4B	60 pcs	3/13/20	3/13/20	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
							Packaging 3 - 37 - B4B	
140	QC 21 - SA	60 pcs	3/13/20	3/13/20	0.00	0.00	QC 21 - SA - 21	DAS 21
							QC 21 - SA - 70	9-89
							QC 21 - SA - 53	MAR 04 2020

Part Op 100 - (Purchasing)
 Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 130 - (Identify as per dwg & Stock Location: Cell)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2792-130P	Extrusion	60 pcs (1 ea)	100-Purchasing	5255011

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2792-130P	60	0	0

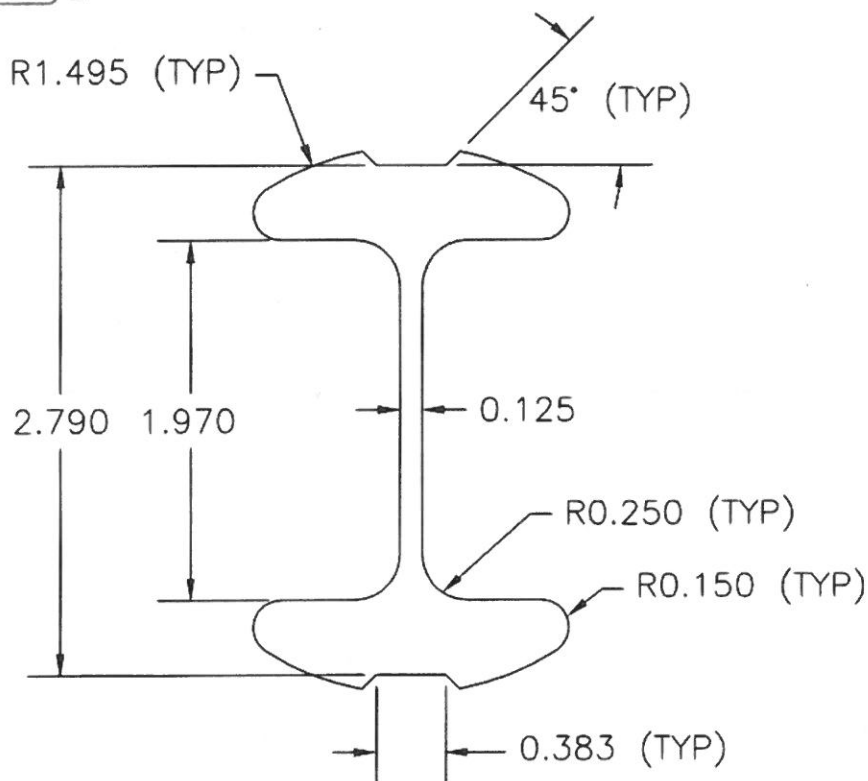
Part Specifications

Specifications could not be found.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2792	REV. A SHEET 1 OF 1
DATE 98.08.13	TITLE EXTRUSION		SCALE 1:1
A	98.08.13	NEW ISSUE	
A1	01.04.17	ADD NOTE #7 <i>[Signature]</i> CP	

RELEASED
98.08.25 DS



GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

DAS
82
9-89

2. MANUFACTURED USING CARADON INDALEX DIE # MS-19248
3. BREAK ALL SHARP CORNERS 0.010 MAX.
4. NO ID TOOLING MARKS.
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
6. ALL DIMENSIONS ARE IN INCHES.
7. PART NUMBER IS D2792-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2792-145 IS 145" LONG)



Dart Aerospace Ltd.
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PURCHASE ORDER **POHB045678**



REVISED

Supplier: SAP001-VC
Hydro
c/o M91634, P.O. Box 11634
Succursale Centre Ville
Montreal
QC
H3C 5Y9 Canada
Phone: 877-922-7272
Fax: 800 563 8310

PO No: POHB045678
PO Date: 1/24/20
Due Date: 2/21/20
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205209	D2792-130P	D2792 Rev A1			Extrusion as per Dwg D2792 Rev A1 Die # MS-19248 Length 130" EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS	Firmed	-	2/21/20	63 pcs	0 pcs	63 pcs	\$62.8846/pcs	\$3,961.73

63 pcs

DAS
82
9-89

FEB 12 2020

Grand Total: \$3,961.73

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Handwritten signature: H. Guerin

Plex 2/12/20 8:19 AM Dart.Guerin.Kimberley



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PURCHASE ORDER
POHB045678



Supplier: SAP001-VC
Hydro
c/o M91634, P.O. Box 11634
Succursale Centre Ville
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H3C 5Y9 Canada
Phone: 877-922-7272
Fax: 800 563 8310

PO No:	POHB045678
PO Date:	1/24/20
Due Date:	2/21/20
Purchase Order	
Revision:	
Revision Date:	
Ship-To Contact:	Guerin, Kimberley Phone: 613-632-5200 Ext: 298 kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via:	Ground
Pymt Terms:	Net 30
Freight Terms:	
Special Comments:	

E-MAILED
2020-01-24

Line Item		Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205209	D2792-130P	D2792 Rev A1				Extrusion as per Dwg D2792 Rev A1 Die # MS-19248 Length 130" EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES, NICKS, DENTS	Firmed	-	2/21/20	52 pcs	0 pcs	52 pcs	\$62.8846/pcs	\$3,270.00
														Grand Total:	\$3,270.00

Order Notes

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Procurement Quality/Clauses

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A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 1/24/20 9:36 AM Dart.Guerin.Kimberley

**Hydro Extrusion Canada, Inc**

325, rue Avro
Pointe-Claire Québec H9R 5W3
Téléphone: (514) 697-5120
Télécopieur: (514) 694-8310

Packing Slip /
Détail de Livraison **0184465**

Order no/
Commande **11189 1**

Ship to/Expédiée à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Sold to/Vendu à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Special Instr / Instr. Spéciales			
Cust No/No du Client 201355		Cust No/No PO du Client HB045678		PPD/PAYÉ X	Ord Dte/Dte Comm 20/01/24		Our Ord Dte/ Notre Dte la Comm 20/02/06		Hydro H.S.T #: R857314058		
PST/TPV *6122-5207		Terms/Cond		Date Required/ Date Requise		Shipped/ Expedi 20/02/06		Shipped Via/ Expédiée Par OTTAWA(1) 7 FEV			
Item No	Ordered Weight Pcs/ Commande Poids Pcs	Hydro Die no/ Matrice d'Sapa	Customer Description/ Description de Client	Alloy & Temper/ Alliage et Trempeage	Length Longueur	Backorder Wgt Pcs Arrière Poids Pcs	This Shipment Bdls Pcs Wght Com Expédiée Ballots Pcs Poids				
1	500 52		DUE = 2020/02/14 ASAP "I" SUPPORT COMPONENT MS 19248 *D2792* 6061 T6 3302MM BUNDLE = 1443476 We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures			1 63 604 KGS DAS 82 9-89					

Aluminum Extrusions - Anodizing - Fabrication - Painting
Profils D'Aluminum - Anodisation - Fabrication - Peinture

The above items were received in good order.
Les articles ci-dessus ont été reçus en bon ordre.

By/Par..... DATE

CDNPACK

CUSTOMER COPY



Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer: **DART AEROSPACE LTD**

Adresse / Address: **1270 ABERDEEN STREET**

HAWKESBURY, ONT K6A1K7

commande Hydro / Hydro order #: **11189**

bon de commande / Purchase order #: **HB045678**

de matrice / Die #: **MS 19248**

Alliage & trempage / Alloy & temper: **6061 T6**

Contrôle / Control #: **49251-1**

Coulée / Cast #: **76808**

Description: **"I" SUPPORT COMPONENT**

Customer Part #: ***D2792***

Conductivité / Conductivity: **N/A**

Propriétés mécaniques Mechanical Properties	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (ksi)	38	45.7
Contrainte élastique Yield stress (ksi)	35	38.4
% élongation dans 2" % elongation in 2"	8	17
Dureté Rockwell E (hre) Rockwell E Hardness		

Composition chimique Réelle / Real chemical composition :

Alliage	Cast no	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6061	76808	0.59	0.22	0.21	0.08	0.8	0.07	0.01	0.01

Certificat

Hydro Extrusion Canada, Inc. certifie par la présente que le métal expédié sous ce rapport a été testé conformément à la norme ASTM B221-14 identifié et / ou spécifications ASME SB 221-17 et les résultats de l'analyse chimique et les propriétés mécaniques des tests sont dans les plages d'acceptabilité des spécifications. La garantie du produit est régie par Extrusion Amérique du Nord. Les conditions standard des ventes sont affichées sur la page web : [Extrusion Amérique du Nord - Modalités et Conditions Standards de la Vente](#)

Certification

Hydro Extrusion Canada, Inc. hereby certifies that the metal shipped under this report has been tested in accordance with the identified ASTM B221-14 and/or ASME SB 221-17 specifications and the results of the chemical analysis and mechanical properties tests are within the acceptable ranges of these specifications. Any product warranty is governed by the Extrusion North America Standard Terms and Conditions of Sale posted at [Extrusion North America Standard Terms & Conditions of Sale](#)

Date : **04-02-2020**

Baharak Sarrafan

Directrice Qualité - Quality Manager

Baharak Sarrafan

Hydro
Extrusion North America
325 Avro
Pointe-Claire, QC H9R 5W3
Canada

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2792-130P

PO / BATCH NO.: POHB045678

DATE: FEB 14 2020

MATERIAL CERT REC'D: YES

QUANTITY RECEIVED: 63 PCS

QUANTITY INSPECTED: 63 PCS

QUANTITY REJECTED: 0

THICKNESS ORDERED: .125 x 2.720 x 1.970

THICKNESS RECEIVED: .125 x 2.790 x 1.970

SHEET SIZE ORDERED: 130"

SHEET SIZE RECEIVED: 130"

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	☒	☐	MINOR SCRATCHES LESS .010
CORRECT FINISH	☒	☐	
CORROSION	☐	☒	
CORRECT GRAIN DIRECTION	☒	☐	
CORRECT MATERIAL PER M-DRAWING	☒	☐	ASTM B221
CORRECT THICKNESS	☒	☐	
PHOTO REQUIRED	☐	☒	
CORRECT REF # TO LINK CERT	☒	☐	HB045678/11189 CAST 76808
CORRECT MATERIAL IDENTIFICATION	☒	☐	
CORRECT M# ON THE MATERIAL	☒	☐	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	☐	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	☐	☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____ DATE: <u>FEB 14 2020</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in